

Work Order ID 152078

Wednesday, October 19, 2016 3:28:33 PM

152078

Page 1

Item ID: PB67-43001-79 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Blade Support Assembly
 Start Date: 10/12/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 10/19/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: OCT 20 2016 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	C

100 Weld per dwg A/R Aluminum rod Batch: 134826 0.00
 Large Fab ***100*** 2 DEC 04 2016 DAS 24 9-89
 Large Fab Memo 0.09
 Large Fab Weld assembly as per dwg PB67-43001
 USE DT10018

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110 2 16-12-06 AD
 QC Memo 0.00
 Quality Control

120 QC5- Inspect part completeness to step on W/O 0.00
120 2 16-12-06 AD
 QC Memo 0.01
 Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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		OTHER :																							

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Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Page 3

Item ID: PB67-43001-79**Accept*****N900040100*****Setup****Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Lower Blade Support Assembly**Start Date:** 10/12/2016 **Start Qty:** 2.00***2*****Cust Item ID:****Required Date:** 10/19/2016 **Req'd Qty:** 2.00***2*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run****Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.03

Quality Control

DEC 19 2016

mE

16-12-19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : _____					

Picklist Print

Wednesday, October 19, 2016 3:28:33 PM

Page 1

Work Order ID: 152078

152078

Parent Item: PB67-43001-79

PR67-43001-79

Parent Item Name: Lower Blade Support Assembly

Start Date: 10/12/2016

Required Date: 10/19/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-17 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-171		Manufactured	No			100	Each	24.0000	6	12			

PR67-43001-171

Mounting Plate

Location

Loc Qty

Loc Code

Mezz2

24

139172

9

148801

15

x 9
x 3

MF 16-11-22

PB67-43001-177

Manufactured

No

100

Each

2.0000

1

2

PR67-43001-177

Short Support Plate

Location

Loc Qty

Loc Code

Mezz2

2

139272

2

MF 16-11-22

PB67-43001-179

Manufactured

No

100

Each

4.0000

2

4

PR67-43001-179

Short Side Plate

Location

Loc Qty

Loc Code

Mezz2

4

139271

4

MF 16-11-22

DQA: _____ Date: _____



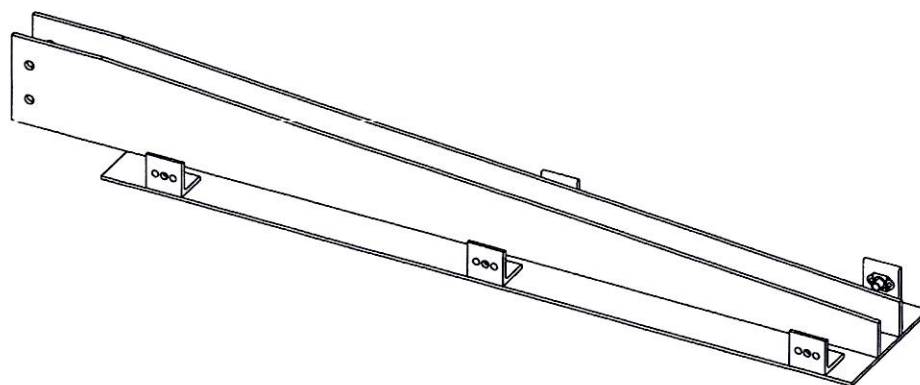
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

ITEM	QTY -79	P/N	DESCRIPTION
1	X	B67-43001-79	LOWER BLADE SUPPORT ASSY
3	6	B67-43001-171	MOUNTING PLATE
4	1	B67-43001-177	SHORT SUPPORT PLATE
5	2	B67-43001-179	SHORT SIDE PLATE
7	12	MS20426AD3-4	RIVET
8	6	MS21075L3	NUT PLATE



B67-43001-79 LOWER BLADE SUPPORT ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 152078 ML5
16-10-20

RELEASED
2009-09-24
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-79" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.96 lbs
- 8) WELDING: PER DART QSI 004

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 11 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.26
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-79 TITLE LOWER BLADE SUPPORT ASSY SCALE NTS REV. C SHEET 1 OF 2 COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DRAWN	<i>[Signature]</i>			
CHECKED	<i>[Signature]</i>			
MFG. APPR.	<i>[Signature]</i>			
APPROVED	<i>[Signature]</i>			
DE APPR.	N/A			
DATE	09.06.26			

8 7 6 5 4 3 2 1

D

C

B

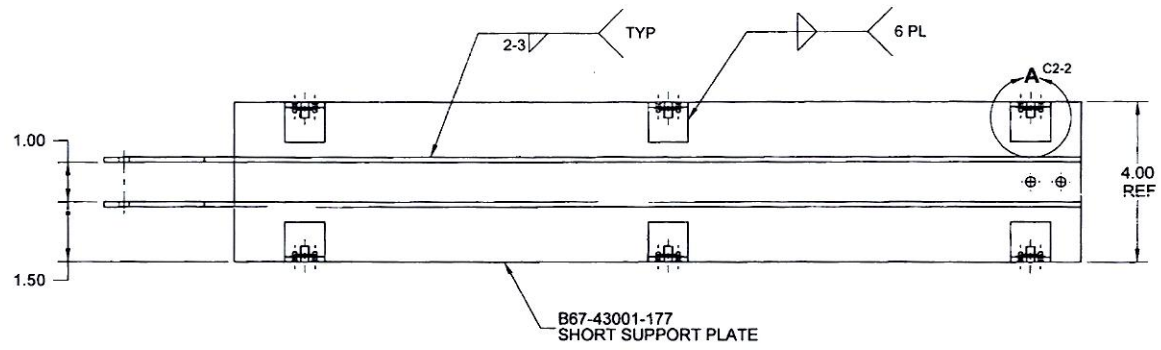
A

D

C

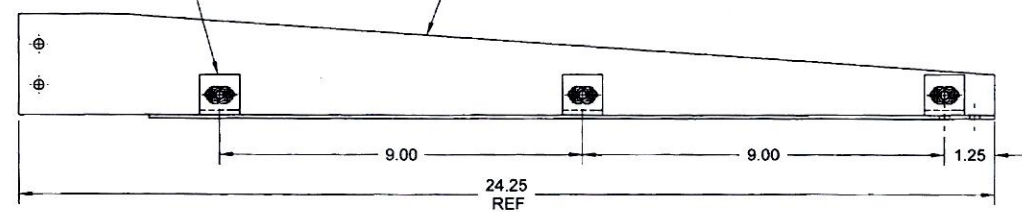
B

A

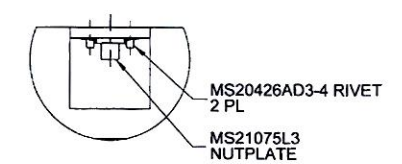


B67-43001-171
MOUNTING PLATE
6 PL

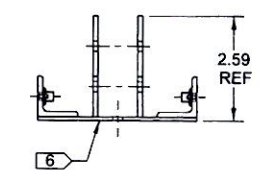
B67-43001-179
SHORT SIDE PLATE
2 PL



B67-43001-79 LOWER BLADE SUPPORT ASSY



DETAIL A C2-2
SCALE 2X, 6 PL



RELEASED
2009-09-24
MP

DESIGN	R/W	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JS</i>	B67-43001-79	SHEET 2 OF 2
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	N/A	LOWER BLADE SUPPORT ASSY	NTS
DATE	09.06.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1